

Work Order ID 66035

Wednesday, February 02, 2011 1:41:52 PM



Page 1

Item ID: D4069-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 2/2/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/9/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

WUK

Date:

11-02-02

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4069

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jaspa Bandsaw

Cut Blanks 1.200" long

cut 11/02/09

10

0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA913

FOLIO REV: _____

DWG REV: _____

DEBURR

*part of ultra pass. finished -
stop 2nd production
per Bill B. 11/02/09*

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 2/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo	0.00							
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Cust Item ID:

Required Date: 2/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

Page 1

Wednesday, February 02, 2011 1:41:49 PM

Work Order ID: 66035



Parent Item: D4069-1



Parent Item Name: Spacer

Start Date: 2/2/2011

Required Date: 2/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-02-18 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.750X1.00 0		Purchased	No			100	f	12.0000	0.11	1.157895			



Delrin Bar

Location

Loc Qty

Loc Code

MAT

12

116779

12

1.157 *ml 11/02/09*

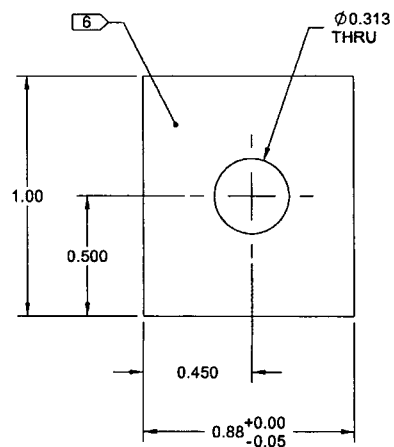
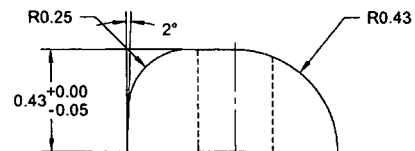
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4069-1 SPACER

66035

RELEASED
2010-04-07
WAP

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF. DART SPEC. M-DELRIN-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D4069-1" USING VIBRATING STYLUS
- 7) WEIGHT: 0.01 lbs

REV.	NEW ISSUE	DESCRIPTION	MB	10.03.31
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.31			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4069

TITLE
SPACER

REV. A
SHEET 1 OF 1
SCALE
NTS

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